

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020060**Date Inspected:** 15-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Hua Jie, Lu Li Qing, Geng W			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Orthotropic Box Girder(OBG)	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12BE, Deck plate (DP3014A) to Deck plate (DP3015A).

SAW welding of weld joint SEG3002*-003; located on assembly, Bay 14, 12BE. Welder is identified as 44771; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2221-LC-S-1.

Assembly, Bay 14, 12BE, Deck Plate (DP3019A to DP3020A & DP3020A to DP3021).

During Random Visual in process Inspection, this QA inspector observed ZPMC NDT personnel performing Ultrasonic testing (UT) on deck panel to deck panel welds. The welds are identified as SEG3002-008, 009. The attached photographs provide additional detail.

Assembly, Bay 14, Traveler rail.

During Random Visual in process Inspection, this QA inspector observed Heat Straightening of Traveler rail 10TR3-011. The attached photographs provide additional detail.

Assembly, Bay 14, 12AE, Bottom plate to Side plate.

FCAW welding of weld joint SEG3001A-011, 005; located on assembly, Bay 14, 12AE. Welder is identified as

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058551, 044774; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

Assembly, Bay 14, 11DE, Bottom plate to Side plate.

SMAW welding of weld joint SSD16A-PP104-009, 026; located on assembly, Bay 14, 11DE. Welder is identified as 067904; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2214-TC-U4B-FCM-1.

Training for Phased Array Ultrasonic Testing.

This QA inspector attended Training for Phased Array Ultrasonic Testing (PAUT) from 1600Hrs. to 1900Hrs.

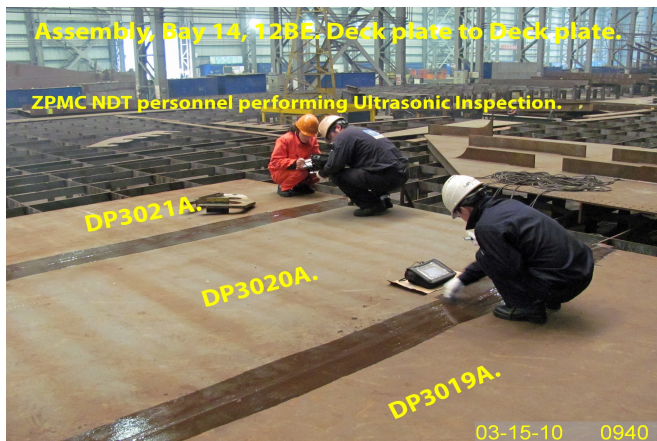
This QA Inspector carried out NDE on following

West of Blast shop, Catwalk railings.

This QA inspector performs Random Visual Testing (VT) of area previously tested and accepted by ZPMC Quality Control personnel (Notification # 005343). The members are identified as

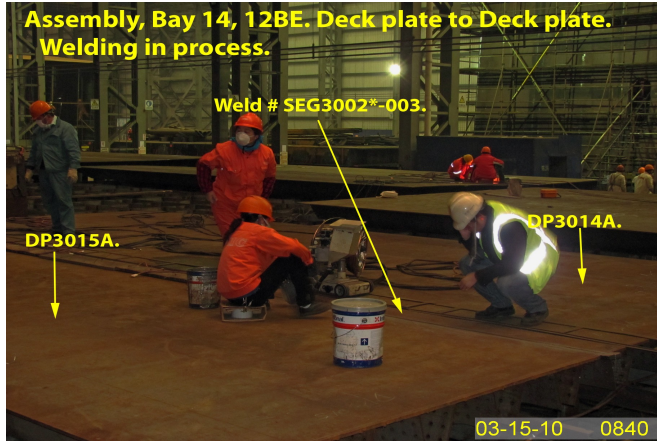
- 1) RL2CA-1 TO 15 (LOT 15 Nos.)
- 2) RL2CB-1 TO 10 (LOT 10 Nos.)
- 3) RL2EA-1.
- 4) RL2EB-1 TO 3 (LOT 3 Nos.)
- 5) RL2EC-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer